

Work Order ID 151932

151932

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Friday, October 14, 2016 1:55:34 PM

Item ID: D4355-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 10/5/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4355	B								

120
120 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut Blank as per D4355-1 File

(4) 0 02/16/10/24

130
130 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 4 Memo 3.45
 HAAS CNC vertical machine #4

DAS 33 9-89 16/12/06

1-Inspect material for defects or damage prior to machining.
 2-Program batch number. Ensure that batch number reflects the W/O.
 3-Machine as per Folio FB049 and Dwg.
 FOLIO REV: AA
 DWG REV: B
 4-Deburr.

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				<u>4</u>	<u>0</u>		DAS 33 9-89 16/12/06
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				<u>4</u>	<u>0</u>		DAS 08 9-89
151 *151* Packaging Packaging	Identify as per dwg & Stock Location: <u>St</u> Memo	0.00 0.01				<u>4</u>			DAS 6 9-89 DEC 12 2016

PPP 150251

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89 ~~DEC 1 2 2016~~

DAS
21
9-89 DEC 1 2 2016

Picklist Print

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Parent Item: D4355-1

D4355-1

Parent Item Name: Bearpaw

Start Date: 10/5/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	91.5000	5.3	22.31579			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

mc 16/10/24

Location

Loc Qty

Loc Code

MAT

77.5

m135497

77.5

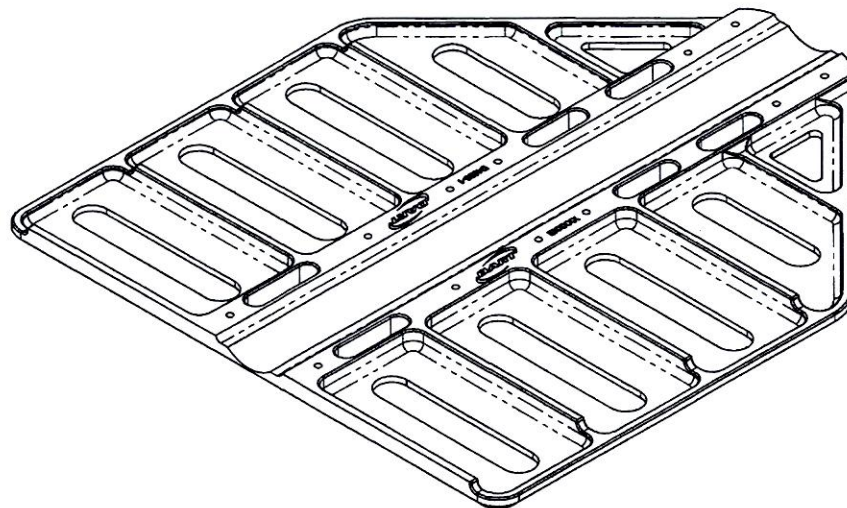
MAT018

14

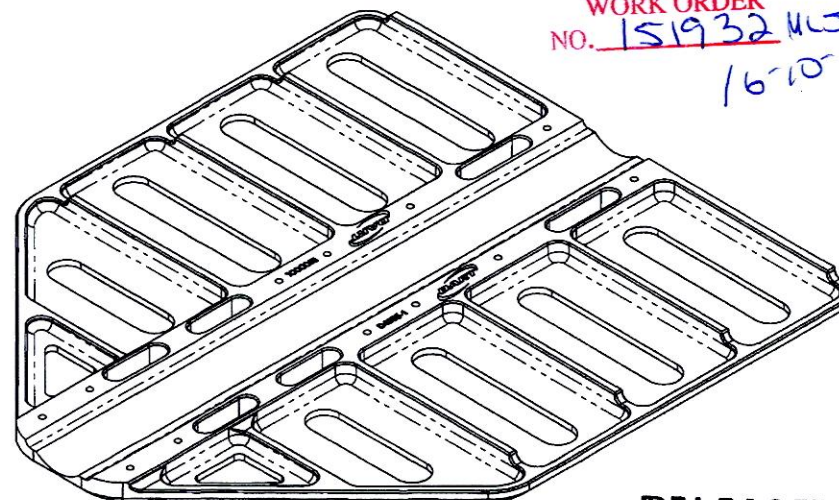
m135013

14

24



D4355-1 206L/407 BEARPAW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151932 WLS
161017

RELEASED
2011-05-10
MD

NOTES:

- 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX"
0.010 - 0.012 DP AS SHOWN
- 7) WEIGHT: 6.88 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B	SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. ZN B4 RAD WAS 2.00. SHT 3, SECT. B-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>WLS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>WLS</i>	D4355	SHEET 1 OF 3
APPROVED	<i>WLS</i>	TITLE	SCALE
DE APPR.	<i>WLS</i>	206L/407 BEARPAW	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

